

5/14

DART AEROSPACE LTD	Work Order:	22636
Description: Doubler	Part Number:	D3248-1
Dwg: D3248 Rev. A	Qty:	40

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	CH	05.03.09	40
2	PG	Issue P/O: <u>2007092</u> Fabricate D3248-1 as per Dwg D3248 Possible Supplier: Industrial Laser Material release note is required	UN	05.09.11	40
3	RG	Receive and inspect for transit damage Ensure material release note is attached	CD	05/06/08	45
4	QC6	Inspect dimensions as per Dwg D3248	Z	05.06.13	45
5	GA	Deburr	ML	05-07-06	45
5A		DRILL HOLES 0.128 AS REQUIRE / 0.257 too	ML	05-07-06	45
6	QC5	Inspect work to Step 5	Z	05-07-11	45
7	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	25.07.14	45
8	QC3	Inspect Chemical Conversion Coat	ML	05-07-14	45
9	ST	Identify and Stock	Z	05-07-14	45
10	AC	Cost / part:			
11	DC	Close W/O Inspect Level 21	RB	05/07/26	45

Rev	Date	Change	Revised By	Approved
A	04.05.25	New issue	KJ/JLM	
B	04.10.26	D3248-1 no longer made in-house	KJ/JLM	<i>[Signature]</i>

Before deburring
drill holes to
size 0.28 as per
dwg 3248

Traveler?
D205-519-015

B22636

RELEASED
[Signature]
05-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

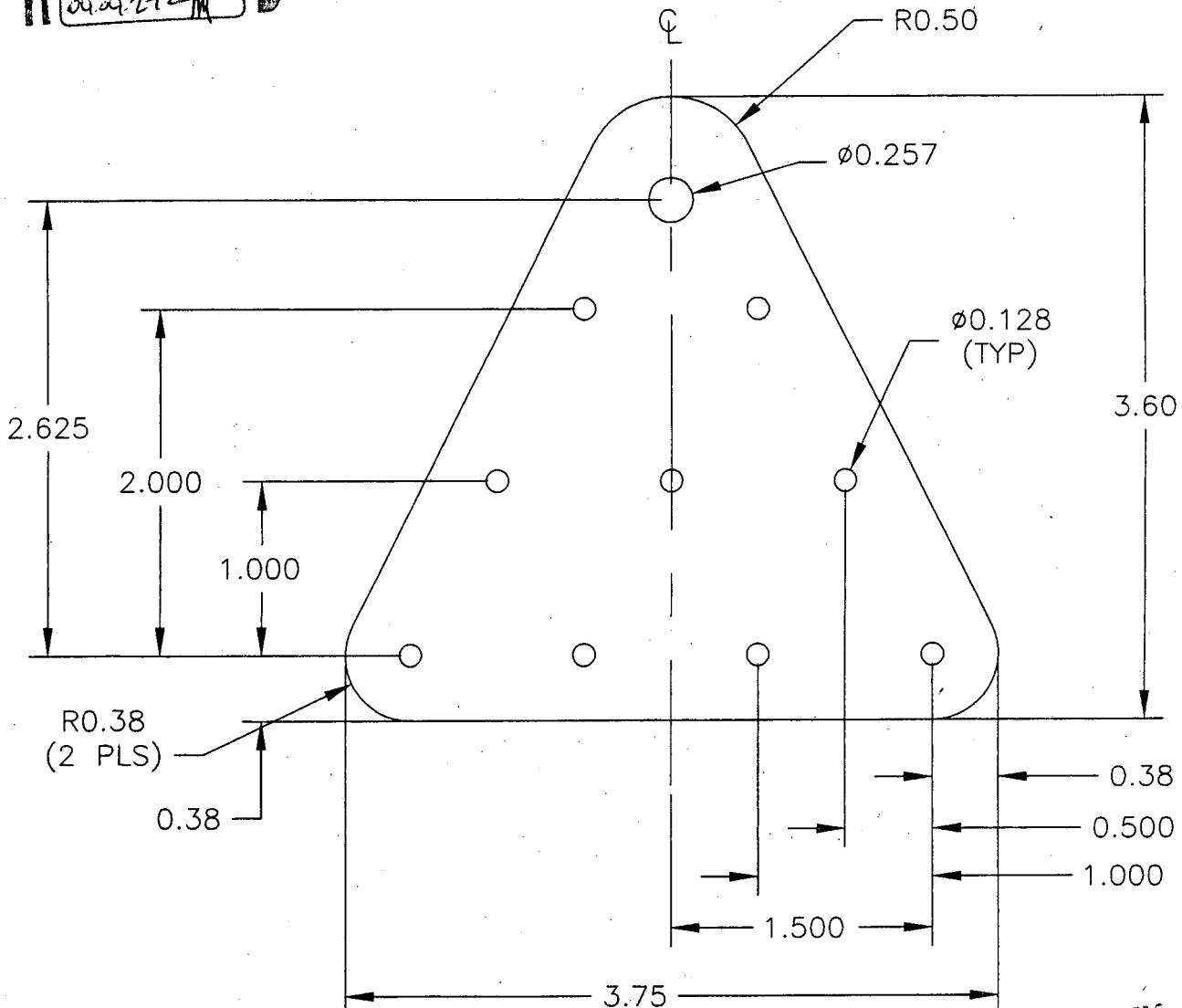
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN <i>TT</i>	DRAWN BY <i>TT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AP</i>	APPROVED <i>TT</i>	DRAWING NO. D3248	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE DOUBLER	SCALE 1:1
A	04.04.06	NEW ISSUE	

RELEASED
04.04.27 off**D3248-1****SHOP COPY****RETURN TO
ENGINEERING****COPY
SPEC.
SUBJECT TO ENDMENT
NOTICE****WORK ORDER****NO. 22636****NOTE:**

- 1) MATERIAL: 5052-H32/H34 SHEET (QQ-A-250/8) 0.063 THICK (REF DART SPEC. M5052H32S.063)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) PART IS SYMMETRIC ABOUT CENTERLINE

06/02/05 THU 10:15 FAX 604 272 0951
INTEGRIS METALS
04/01/05 FRI 14:03 FAX 604 272 0951
INTEGRIS METALS
APR-01-2005 13:46

06/02/05 MTR MINNEAPOLIS 763 717 7112 P.02/03
+ MTR MINNEAPOLIS 763 717 7112 P.02/03

Fax Server

INTEGRIS METALS
PAGE 001/002

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described herein, including any specifications forming part of the description and that samples representative of this material meet the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Soder
Mark J. Soder
Mech. Valve
Standard Manufacturing Division/Valve

Kenton P. Young
Kenton P. Young
Quality Assurance Manager

Alcoa Inc.

PITTSBURGH, PA. DAVENPORT WORKS

Ship From: RIVERDALE, IA.

132321 28027
Ship Date B/L No. Invoice No. Alcoa No. Item
2005-01-11 67993 81618 DS-04819-1
P.O. No./Govt Contract No. Customer

Page 1

419184:20050119 INTEGRIS MET-COON

Ship To: INTEGRIS METALS
455 85TH AVE. NW
COON RAPIDS, MN 55433

Item Description
.063 IN TX X 48.000 IN W X 184.000 IN L CAT D 126153 (N) A/T 2026-
T3 FLAT SHEET MILL FINISH <P/N 54184155>, PAR AMS-QQ-A-
250/4 REV A & (EXCEPT OIL &
SHARPING) AMENDMENT REV N & (EXCEPT HEAVING)
ASTM B203 REV 04 ((MARKED)) INTERLEAVED SKID
WTG: 4500 LB QMAN TOL +/-10 %
CQR D126153 REV 26 QRR 031776 CUST REQ 05-01-
19 *** W/B 05-01-22 ***

Qty	Package	Ticket	Lot	Weight	Quantity	UOM	Pc Id/Ser#
1	249383		758041	1932	45	PC	

Notes for CQR: D126153-26

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/4 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/4E, AMENDMENT 1.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/4.

CQR: D126153-26 -Specification Limits -----

Type	Dir	UTS	TYS	EL40
		KSI	KSI	KCI
T3	Long Transv.	Max		
		Min 61.0	62.0	15

Chemical Composition	Other Other										
	Si	P	Cu	Mn	Mg	Ca	Zn	Al	Each	Total	Aluminum
	Max	.50	.50	4.5	.9	1.6	.10	.25	.15	.05	.15
Alloy 2024	Min										REMAIN

Lot: 758861 -Mechanical, Physical, Metallurgy, Quantometer Results -----

Type	Dir	No.	UTS	TYS	EL40
		Test	KSI	KSI	KCI
T3	Long Transv.	6	Max 67.7	45.9	20
		Min 67.2	45.7	16	

INTEGRIS 0/2 359124

06/02/05 THU 10:15 FAX 604 272 0951 INTEGRIS METALS
Integris Metals 6/2/2005 11:58 PAGE 002/002

04/01/05 FRI 14:03 FAX 604 272 0951 INTEGRIS METALS
APR-01-2005 13:46 INTEGRIS METALS

→→→ MTR MINNEAPOLIS
763 717 7112 P.03/03

CERTIFIED INSPECTION REPORT

Very likely many of these are not concerned in the production of the *lactic* acid, but are rather a part of the bacterial flora and that satisfy a specific requirement demanded by the bacteria in the production of the *lactic* acid.

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Digitized by srujanika@gmail.com

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Lot:
Cast No.
H9156126

	PE	PC	PA	PM	PG	CR	2H	TL
chemical	81	PR	CJ	AM	PG	CR	2H	TL
Actuals	.87	.18	4.5	.63	1.5	.01	.08	.03

<u>Ship Date</u>	<u>Blk. No.</u>	<u>Invoice No.</u>	<u>Alloc. No.</u>	<u>Item</u>
2015-01-21	67991	81618	DS-64819-1	
<u>P.O. No./Cart Contract No.</u>	<u>Customer</u>			
419344-20050119	INTEGRIS WIL-0304			

PITTSBURGH, PA. 15219
SHIP FROM: RIVERDALE, MD.

Page

TOTAL P.E